Work Orde February 3, 2010												Page 1
Revision ID:	D4027-041 Hose Clamp Ass	sembly	,	Accept	1111/191 BJB 121/4 BBJ/4 BBJ/4 I			S	Setup	Start Stop		
Start Date: Required Date: Reference:		Start Qty: 2.00 Req'd Qty: 2.00	1884 1484 1684 1884 1884 1884		Cust Item II Customer:) :						
Approvals:	Process Plan	n:	Date: <u>////////////////////////////////////</u>	Tooling: SPC (Y/N):	Date Date Date Date Date Date Date Date	te: te:		I	Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description	,	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr		sion Nbr RELIM						QX)			
Small Fab		Memo Assemble	as per dwg	0.00 0.00	nd wi	106	/16					
QC Quality Control		QC5- Inspect part cor	npleteness to step on W/O	0.00 - Siolos 0.00 inspecta Release		,						

120

Packaging

Packaging

Identify as per dwg & Stock Location.

Memo

0.00

0.00

10 K/31 DDS



Dart Ae	rospace L	.td						\$ A
W/O:			WORK	ORDER CHANGES	···			•
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval* QC Inspector
Part No	:	PAR #:	Fault Category:	NC	R: Yes	No DQA:	Date: _	
Resolution:		olution:	Disposition:	QA	: N/C CI	Date: _		
NCR:			WORK ORDER	NON-CONFORMANCI	E (NCR	R)		
		Description of NC	Corr	ective Action Section B		- Verification	Approval	Annroyal
DATE	STEP	Section A	Initial	Action Description	Sign &	Section C	Approval Chief Eng	Approval QC Inspector

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Ammanai	Ammunical
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						Ì		
	1				1			ľ

Work Order ID 55882



Page 2

February 3, 2010 1:53:58 PM

Item ID:

D4027-041

Accept



Setup Start



Stop

Revision ID:

Item Name:

Hose Clamp Assembly

Start Date:

2/03/10 Start Qty: 2.00

Required Date: 2/10/10

Req'd Qty: 2.00

Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

SPC (Y/N):

Date:

Stop

Start



Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours** Draw Number

Draw Rev.

Date:

Accept Plan Code Qty

Reject Qty

Run

Reject Number

Insp. Stamp

130

QC21- Final Inspection - Work Order Release

0.00

CZ10[8]31

Quality Control

Memo

0.00

POSITIVE RECALE FRECTIVE DESCRIPTION OF 31

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	GES		-			r
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					4					
Part No	:	PAR #:	Fault Cate	gory:	NCR:	: Yes N	lo DQ	A:	Date:	
	Re	esolution:	Disposition	າ:	QA: I	N/C Clo	sed:		Date:	
NCR:		,	WORK ORDI	ER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC			ction B	Ciam 0	Verific	ation	Approvai	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
		,								
									}	
									·	

Picklist Print

. February 3, 2010 1:54:02 PM

Work Order ID: 55882

Parent Item:

Parent Item Name:

D4027-041

Hose Clamp Assembly

Comments:

IPP rev A 10.02.01 new issue Prelim EC verified by:JLM



Start Date: 2/03/10

Required Date: 2/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN743-13		Purchased	No			100	Each	20.0000	2.0000			
BRACKET	198 1411 1881			33 7		•	,	3706		-	\$ 10/0	4/140
				<u>Warehous</u> Locat	_	Loc	<u>Viv</u>	Loc Code			<i>U</i>	
				Main War								
				ST329	•		20		_			
					113706		20		_			
D4027-1		Manufactured	No			100	Each	0.0000	2.0000 111111111111111111111111111111111	5195	Sis colo	4/140
Hose Clamp D4027 5 D462 7 - 7	III 6	Manufactured	No			100	Each	0.0000	2.0000 	5879 R	Su volu	4/192
Rubber Cushion MS21042L06	10.08. 50	Purchased	No			100	Each	190.0000	B 5	5888 W.L	6/08/	30(24)

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	190	***
109167	2	
110123	9	
110731	14	
111548	1	- 18109 l
112433	64	
112465	100	

Page 1

Dart Aerospace Ltd

								:	
W/O:			WO	RK ORDER CHANG	BES				,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Res	solution:	Disposition	l:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verifi	ication	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector
							 .		
	-								

Picklist Print

. February 3, 2010 1:54:02 PM

Work Order ID: 55882

Parent Item Name:

Parent Item:

D4027-041

Hose Clamp Assembly

Comments:

IPP rev A 10.02.01 new issue Prelim EC verified by:JLM



Start Date: 2/03/10

Required Date: 2/10/10

Page 2

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-S28		Purchased	No			100	Each	173.0000	2.0000			

Screw

Warehouse	<u>Lo</u>	c Oty	Loc Code				
Location							
Main Warehouse							1 (2)
ST		173			<u></u>		14/19
11334		96			<u></u>	$\langle n \rangle$	19041
4824		29			2	. 8	
8170		48					
	100	Each	90.0000	2.0000			

NAS1149DN632J Purchased

Washer

Warehouse Loc Code Loc Qty

Location Main Warehouse ST

No

112794

90 90

So lelouth o

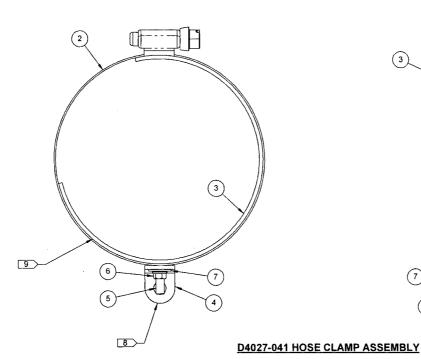
Dart Aerospace Ltd

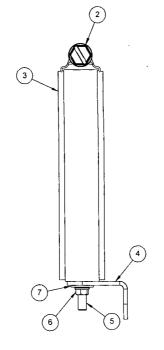
W/O:		The state of the s	WO	RK ORDER CHANG	GES				· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-				

Part No	:	PAR #:	Fault Categ	ory:	NCR: Ye	es No	DQ	\:	Date:	
	Res	solution:	Disposition	:	QA: N/C	Close	ed:		Date:	 .
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Initial		ction B	n &	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Da Da		Section	on C	Chief Eng	QC Inspector
este:	÷									
		· · · · · · · · · · · · · · · · · · ·					· .			
_										
									Į	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER	
1	x	D4027-041	HOSE CLAMP ASSEMBLY	JCA-M47-2-20	1
2	1	D4027-1	HOSE CLAMP		- 1
3	1	D4027-5	RUBBER CUSHION		1
4	1	D4027-9	BRACKET, SUPPORT ANGLE		1
5	1 (104)	MS24693S28	SCREW /		1
6	1	MS21042L06	NUT /		1
7	1	NAS1149DN632J	WASHER 🗸		1







PA2 NEW ISSUE

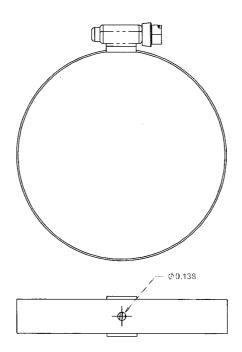
SHOPCTY RETUR., 1 ENGINEERING UNCONTROLLED CON SUBJECT TO AMPHOMENT WITHOUT NOTICE

1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs
8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

PRELIMINARY ISSUE 4 10.01.20

			1 1					
REV.	D	ESCRIPTION	BY	DATE				
DESIGN	8	DART AEROSPACE LTD						
DRAWN	8 51	HAWKESBURY, ONTARIO, CANADA						
CHECKED	A	DRAWING NO.		REV. PA2				
MFG. APP	マ. 足	D4027		SHEET 1 OF 7				
APPROVE	D .	TITLE		SCALE				
DE APPR.		CLAMP		NTS				
DATE .	10.01.20	COPYRIGHT © 2010 THIS DOCUMENT IS PRIVATE AND CONFIDENTY NOT TO BE USED FOR ANY PURPOSE OR COP		ESS CONDITION THAT IT IS				

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20





PRELIMINARY ISSUE NOTES: 1) MATERIAL: MADE FROM D4062-56 2) FINISH: N/A 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

10.01.20

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

8) DRILL Ø0.138 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV, PA2 D4027 MFG. APPR. SHEET 3 OF 7 APPROVED SCALE CLAMP DE APPR. NTS COPYRIGHT © 2018 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONTRIBUTION AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PUMPOSE OR COMMINICATE TO GAY OTHER PERSON WITHOUT WONTEN PERSONS PROBLEMAT AFRONCE LTD. DATE 10.01.20

1	8		7	6	5	4 3		2		
Γ	ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER			2		l
ŀ		-041 X	D4027-041			4			A	ĺ
-	1	 ^	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20	_		A		l
ł	2	1	D4027-1	HOSE CLAMP		1		/		i
Ì	3	1	D4027-5	RUBBER CUSHION		-				i
P	4	1	D4027-9	BRACKET, SUPPORT ANGLE		1		\(\bar{\pi}\)	\ \\\\\	D
Ì	5	1	MS24693S28	SCREW		7			./	i
[6	1	NAS1149DN632J	WASHER]		1		i
ļ	7	1	MS21042L09	NUT]				
						(2))		J	1
_		•			•	\mathcal{F}			_	L_
Ì					79					
										1
1						(3)				i
c										_
										С
									-	l
					///			EHENCE ONT!		ĺ
					//	[]		"VO 324		
								-MENO-		l
- r-				1				103	43L	·-
				h	(3) //				70	ĺ
								•		l
					Y //					
										1
В										В
			9>							1
			ترق	(7)	6		(4)			l
									_	ĺ
			~	(5)	(4)		(5)	**OFIFAS	s eta 📗	ĺ
				(/0)	\circ	₩			0.5	l
				8		Ш		B B 2010 - U5-	,	<u> </u>
	1				D4027-041 VEN	IT CLAMP ASSEMBLY		<i>50</i>	**	
					D-7021-0-11 VLI	· OLIMIN AGOLINDLY				
						_	A NEW ISSUE		10.04.16	-
							REV.	DESCRIPTION	10.04.16 BY DATE	i
Α	NOTES:		:			L		DART AERO		۵ ا
^	1) MATERIAI 2) FINISH: N	'A					DESIGN DRAWN	HAWKESBURY, OF	NTARIO, CANADA	^
	3) TOLERAN	CES: PER	DART QSI 018 UNLESS OTHER ESS OTHERWISE NOTED	WISE NOTED		land	CHECKED B	DRAWING NO.	REV. A	
	5) BREAK SI	HARP EDGI	ES: 0.005 TO 0.010 MAX	A44 AND DALLIONS EINE			MFG. APPR. B	TITLE	SHEET 1 OF 7 SCALE	1
	7) WEIGHT:	0.06 lbs		-041" AND B/N USING FINE POINT PE		1	DE APPR.	CLAMP	· NTS	ŀ
	8) ATTACH I	04027-9 BR	ACKET USING MS24693S28 SC	REW, MS21042L06 NUT AND NAS114 MP USING 3M CONTACT CEMENT IN	49DN632F WASHER		DATE 10.04.16	COPYRIGHT © 2010 BY THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IN TO BE USED FOR ANY PURPOSE OR COPIED OR		
	3) GLUE D40	121-0 NUBB	THE COSTROIT TO D4027-1 CLAI	WI GOING SWI GONTACT CEIVIENT IN	FOOTHOR NO SHOWIN		13.04.10	NOT TO SE USED FOR ANY PURPOSE OR COPIED OR WRITTEN PERSOSSION FRO	COMMUNICATED TO ANY OTHER PERSON WITHOUT IN DART AEROSPACE LTD	J

COPYRIGHT © 2016 BY DART AEROSPACE LTD

THE COCAMOTIO FRANTE HIS DESERVAL HIS OLD MERCON THE STORES COMMON HIS TO

THE COCAMOTIO STANTE HIS DESERVAL HIS DESERVAL HIS DESERVATION DE HIS TORES COMMON HIS TO

WRITTLY FORCESTOR HIS TORES OF THE TORES OF THE PERSON WITHOUT

WRITTLY FORCESTOR FAIR ARROSPACE LTD

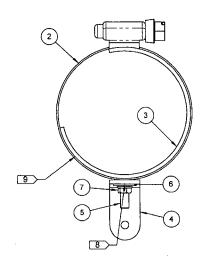
2

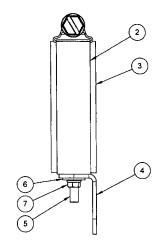
ITEM NO. QTY.		PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER	
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35	
2	1	D4027-3	HOSE CLAMP		
3	1	D4027-7	RUBBER CUSHION		
4	1	D4027-9	BRACKET, SUPPORT CLAMP		
5	1	M\$24693\$28	SCREW		
6	1	NAS1149DN632J	WASHER		

NUT

MS21042L09







3

PEFERENCE ONLY

D4027-043 VENT CLAMP ASSEMBLY

4



8

1	NOTES:
	1) MATERIAL: N/A
ł	2) FINISH: N/A
ı	3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
ı	4) UNITS: INCHES UNLESS OTHERWISE NOTED
1	5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
1	6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
1	7) WEIGHT: 0.06 lbs
1	8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
-	9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

DESIGN DRAWN		DART AERO	SPACELTD
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	B	D4027	SHEET 2 OF 7
APPROVED	NO.	TITLE	SCALE
DE APPR.	_#	CLAMP	NTS
DATE 10.04.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPONITY AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPONITY OF TO ANY OTHER PERSON WITHOUT	

3

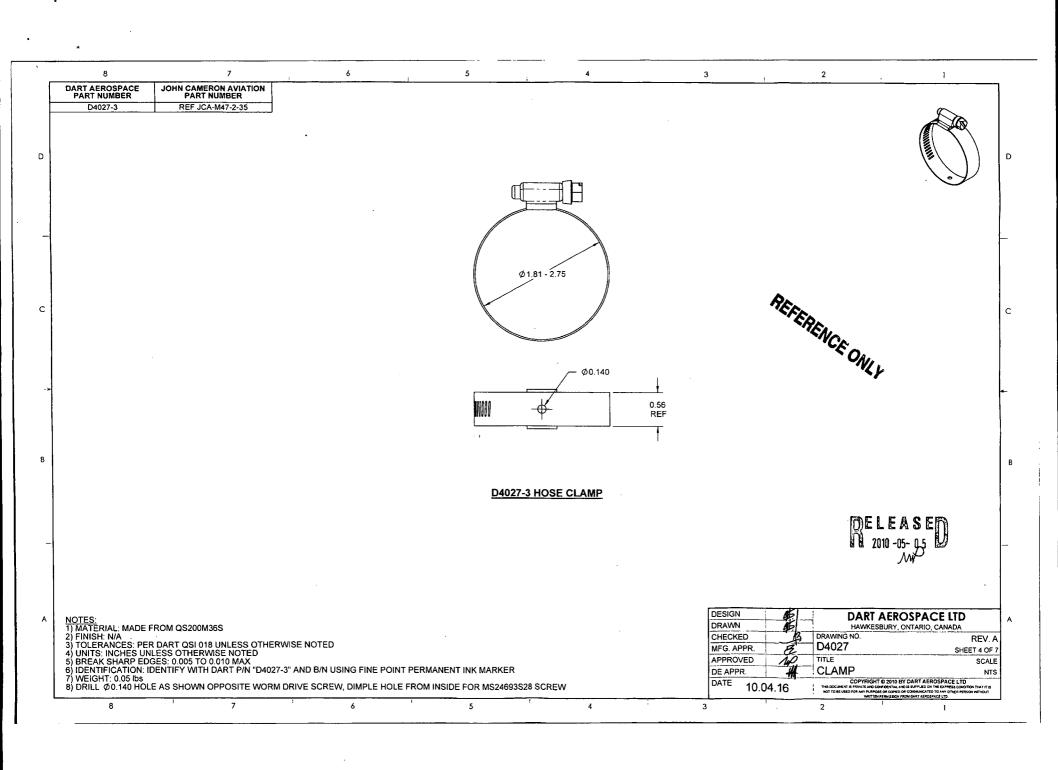
Α

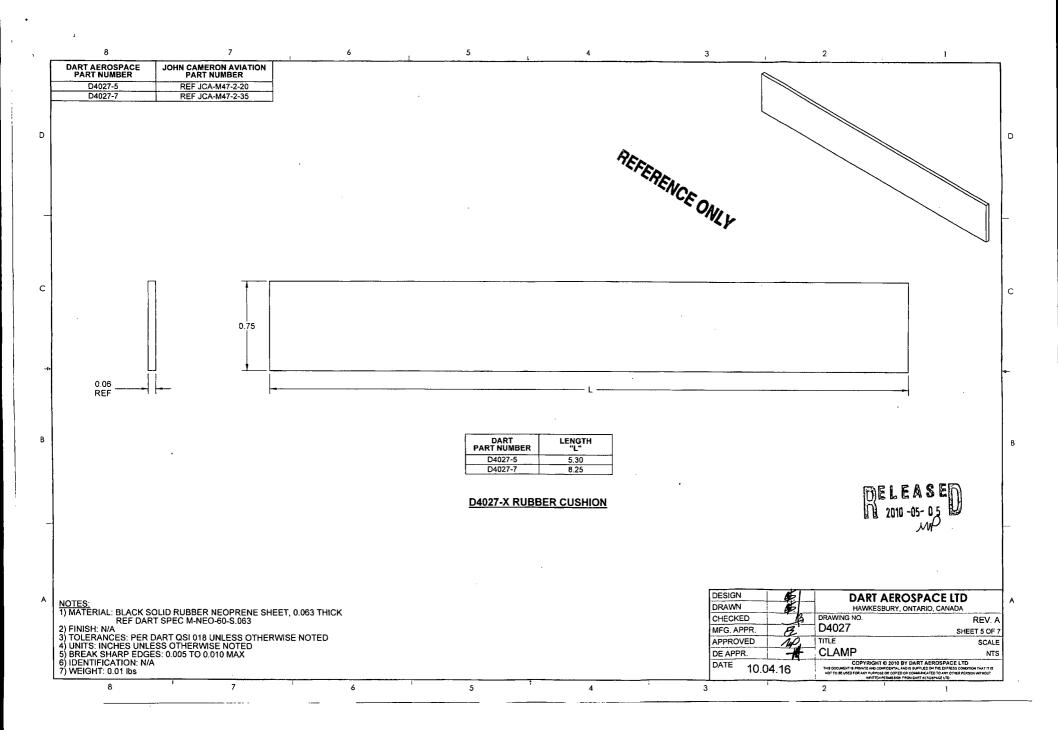
D

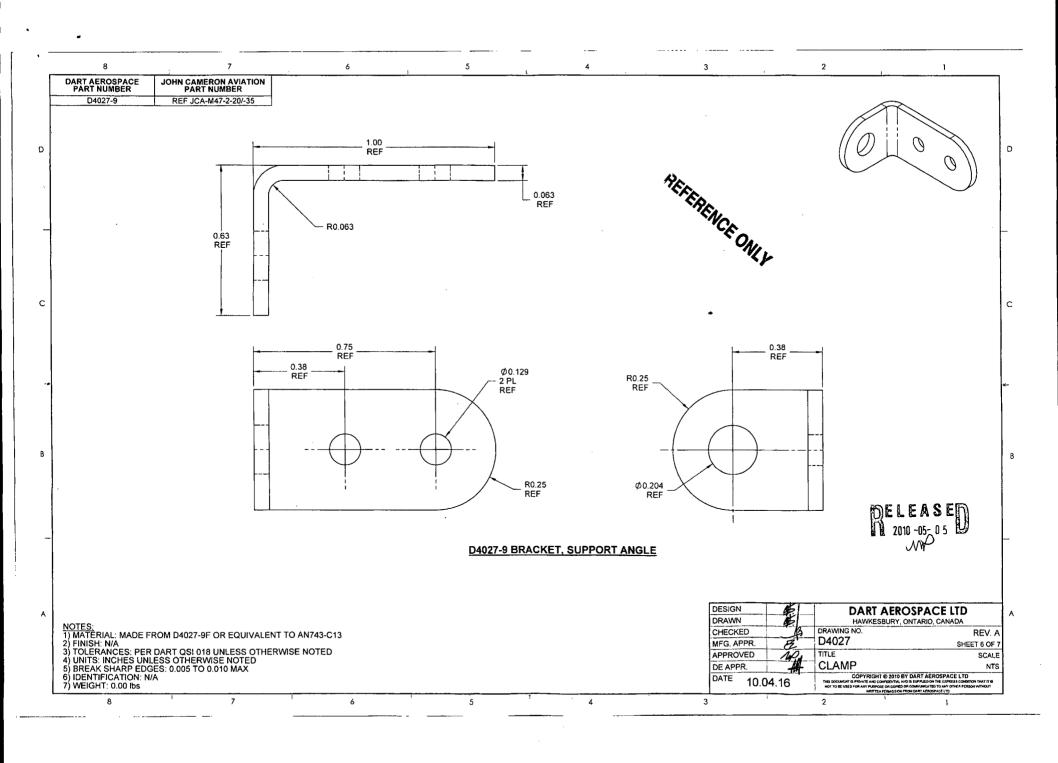
4

2

5 6 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4027-1 REF JCA-M47-2-20 D Ø3.06 - 4.00 REFERENCE ONLY Ø0.140 0.56 REF В D4027-1 HOSE CLAMP DESIGN **DART AEROSPACE LTD** NOTES:
1) MATERIAL: MADE FROM QS200M56S
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.05 lbs
8) DRILL \$0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4027 MFG. APPR. SHEET 3 OF 7 APPROVED TITLE SCALE CLAMP DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRINATE AND COMMENTAL AND IS SUPPLED ON THE EXPRESS CONDITION
NOT TO BE USED FOR ANY PRIMESS OF YOU DO COMMUNICATE TO ANY CITYER PERSON IN DATE 10.04.16 6 5 2 8 4 3







8 2 D D 0.57 REF BEND LINE Ø0.129 2 PL Ø0.204 GRAIN DIRECTION 0.50 R0.25 0.646 0.375 -TYP 0.063 REF **—** 1.52 -**D4027-9F FLAT PATTERN** NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK PER AMS5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A 2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 lbs D4027 SHEET 7 OF 7 MFG. APPR. APPROVED TITLE SCALE CLAMP DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS DOCUMENT BANTE WID COMPENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS
HOT TO BE USED FOR ANY PURPOSE OR COMPONING THE TO TAKE THIS PERSON WITHOUT DATE 10.04.16 8 7 6 5 4 3 2